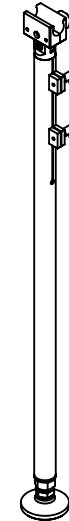
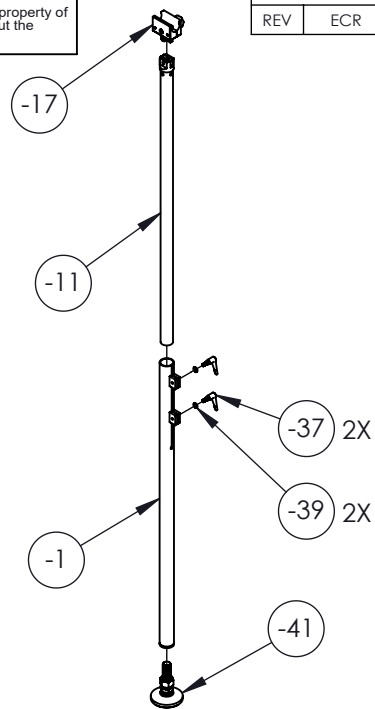


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REVISIONS			
REV	ECR	DESCRIPTION	DATE

ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			X		-1	1	OUTER TUBE WELDMENT			2
			1		-3		OUTER TUBE	6061 TELESCOPIC TUBE		3
			1		-5		SWIVEL FOOT POST	6061		4
			2		-7		CLAMP PLATE	6061		5
			2		-9		CLAMP PLATE, THREADED	6061		6
		X			-11	1	INSIDE TUBE WELDMENT			7
		1			-13		INSIDE TUBE	6061 TELESCOPIC TUBE		8
		1			-15		POST	6061		9
	X				-17	1	CRADLE ASSEMBLY			10
X	1				-19		UPPER CRADLE ASSEMBLY			11
1					-21		UPPER CRADLE CLAMP	6061		12
	1				-23		UPPER CRADLE CLAMP	6061		13
2				B/O	-25		DOWEL PIN	S.S.	ØM6 X 50mm (MCMaster-CARR #91585A700)	11
	1			B/O	-27		HEADLESS CLEVIS PIN	S.S.	Ø3/8 X 1-1/4 USABLE (MCMaster-CARR #93890A154)	10
	1			B/O	-29		HEX HEAD CAP SCREW	STEEL	M8 x1.25 X 65mm (MCMaster-CARR # 91280A979)	10
	2			B/O	-31		COMPRESSION SPRING	MUSIC WIRE	Ø.022 X .3 O.D. X 3/4 (MCMaster-CARR #9657K286)	10
	1			B/O	-33		SPRING PIN	STEEL	M3 X 12mm (MCMaster-CARR #91611A155)	10
	1			B/O	-35		SEVEN LOBE KNOB	S.S.	5/16-18, 1-9/16 O.D. (MCMaster-CARR #8558K6)	10
				B/O	-37	2	ADJUSTABLE HANDLE	STEEL	5/16-18 X 3/4 X 2-9/16 (MCMaster-CARR #64835K691)	1
				B/O	-39	2	FLAT WASHER	STEEL	Ø5/16 (MCMaster-CARR #98023A030)	1
				B/O	-41	1	SWIVEL FOOT	STEEL	1-8 X 3-1/2, Ø4 (MCMaster-CARR #6111K64)	1
ASSY -19	ASSY -17	ASSY -11								

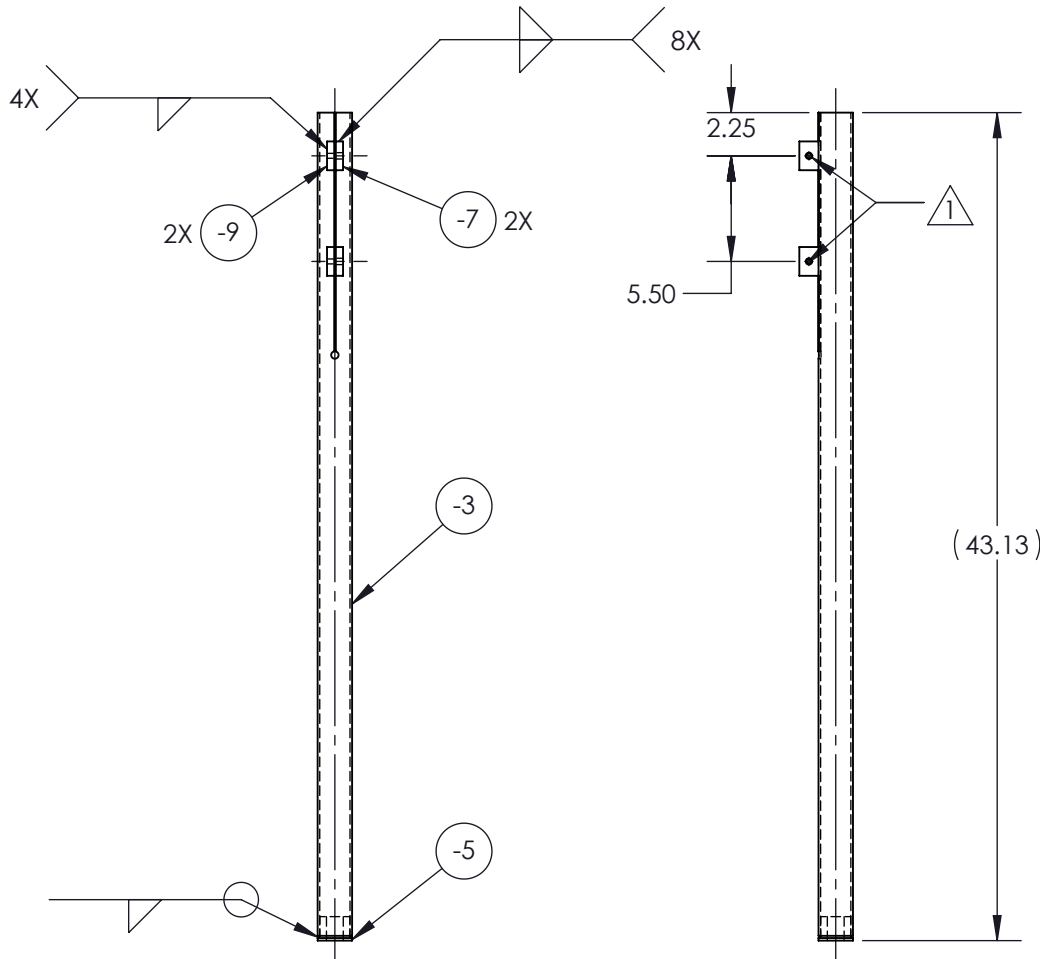
NOTE:
REFERENCE EUROCOPTER T/N 117-30001W2.



TITLE	
TAIL BOOM SUPPORT	
DWG NO.	REV
RBE117-30001W2	1
MAT'L	UNLESS OTHERWISE SPECIFIED
HEAT TREAT FINISH	DIMENSIONS ARE IN INCHES
	.XXX ± .005 FRACTIONS ± 1/8
	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125✓
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: RJC 07/10/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DD 07/10/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: AA 07/14/2017	
QA APPR: JL 07/19/2017	USED ON MODEL
APPROVED: JAG 07/26/2017	EC145, EC645
SCALE 1:24	DATE 7/10/2017
	SHEET 1 OF 13

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				APPROVED



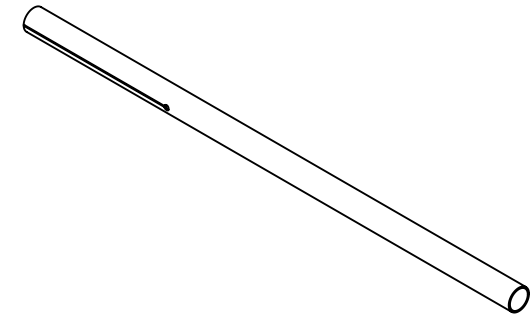
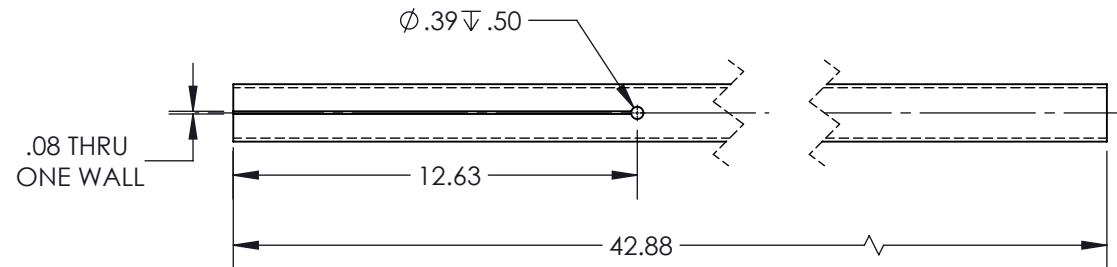
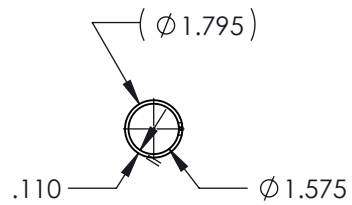
(-1)
OUTER TUBE WELDMENT

NOTE:
ALIGN HOLES -7 & -9.

DART AEROSPACE	
TITLE TAIL BOOM SUPPORT	
DWG NO. RBE117-30001W2-1	REV 1
MAT'L HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125°
DRAWN BY: RJC 07/10/2017	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 07/10/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 07/14/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 07/19/2017	USED ON MODEL
APPROVED: JAG 07/26/2017	EC145, EC645
SCALE 1:10	DATE 7/10/2017
SHEET 2 OF 13	

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REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



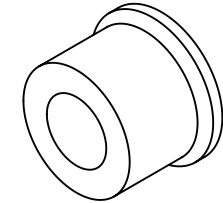
③

OUTER TUBE

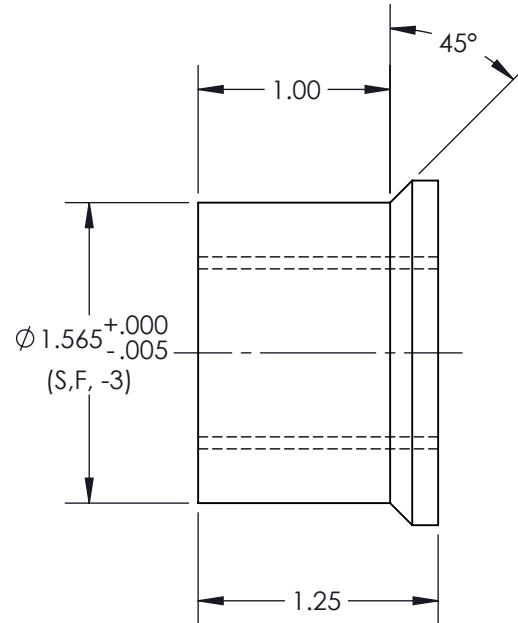
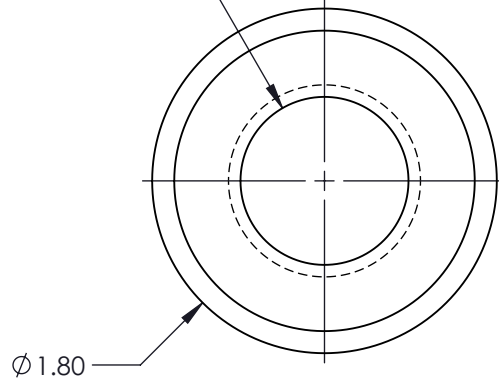
DART AEROSPACE	
TITLE TAIL BOOM SUPPORT	
DWG NO. RBE117-30001W2-3	REV 1
MAT'L 6061 TELESCOPIC TUBE	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE - 1	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125/
DRAWN BY: RJC 07/10/2017	1. BREAK ALL SHARP EDGES
CHECKED: DD 07/10/2017	.015 x 45° OR .015R
OPPS APPR: AA 07/14/2017	2. DIMENSIONAL LIMITS APPLY
QA APPR: JL 07/19/2017	AFTER PLATING
APPROVED: JAG 07/26/2017	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:6	USED ON MODEL
DATE 7/10/2017	EC145, EC645
	SHEET 3 OF 13

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REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



1-8 UNC - 2B THRU ALL



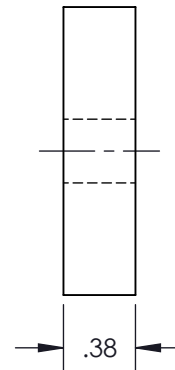
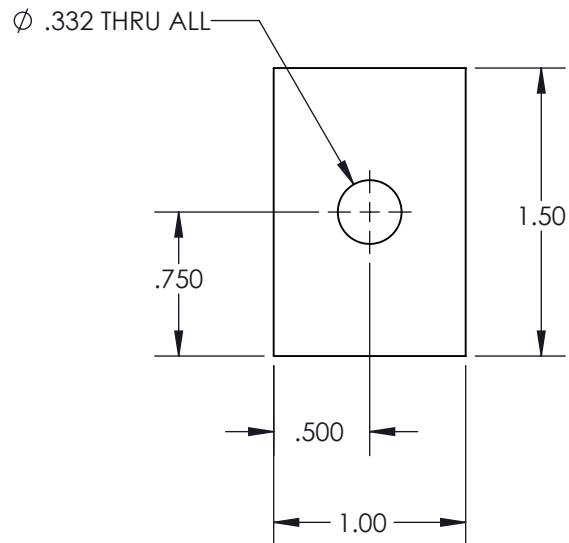
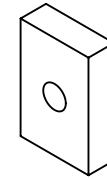
(5)

SWIVEL FOOT POST

DART AEROSPACE	
TITLE TAIL BOOM SUPPORT	
DWG NO. RBE117-30001W2-5	REV 1
MAT'L 6061	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH SEE -1	.XX ± .01 ANGLES ± .5°
SPEC	.X ± .1 SURFACES = 125/✓
DRAWN BY: RJC 07/10/2017	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 07/10/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 07/14/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 07/19/2017	USED ON MODEL
APPROVED: JAG 07/26/2017	EC145, EC645
SCALE 1:1	DATE 7/10/2017
SHEET 4 OF 13	

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REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



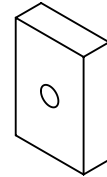
(-7)

CLAMP PLATE

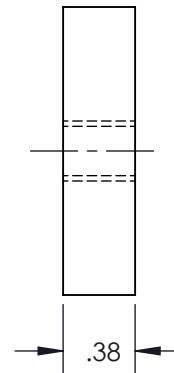
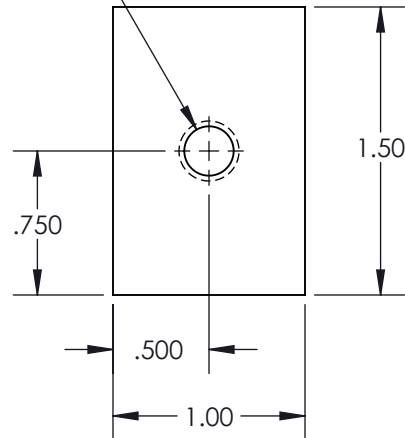
DART AEROSPACE	
TITLE TAIL BOOM SUPPORT	
DWG NO. RBE117-30001W2-7	REV 1
MAT'L 6061	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125°
DRAWN BY: RJC 07/10/2017	1. BREAK ALL SHARP EDGES
CHECKED: DD 07/10/2017	.015 x 45° OR .015R
OPPS APPR: AA 07/14/2017	2. DIMENSIONAL LIMITS APPLY
QA APPR: JL 07/19/2017	AFTER PLATING
APPROVED: JAG 07/26/2017	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	EC145, EC645
SCALE 1:1	DATE 7/10/2017
	SHEET 5 OF 13

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				APPROVED



5/16-18 UNC - 2B THRU ALL



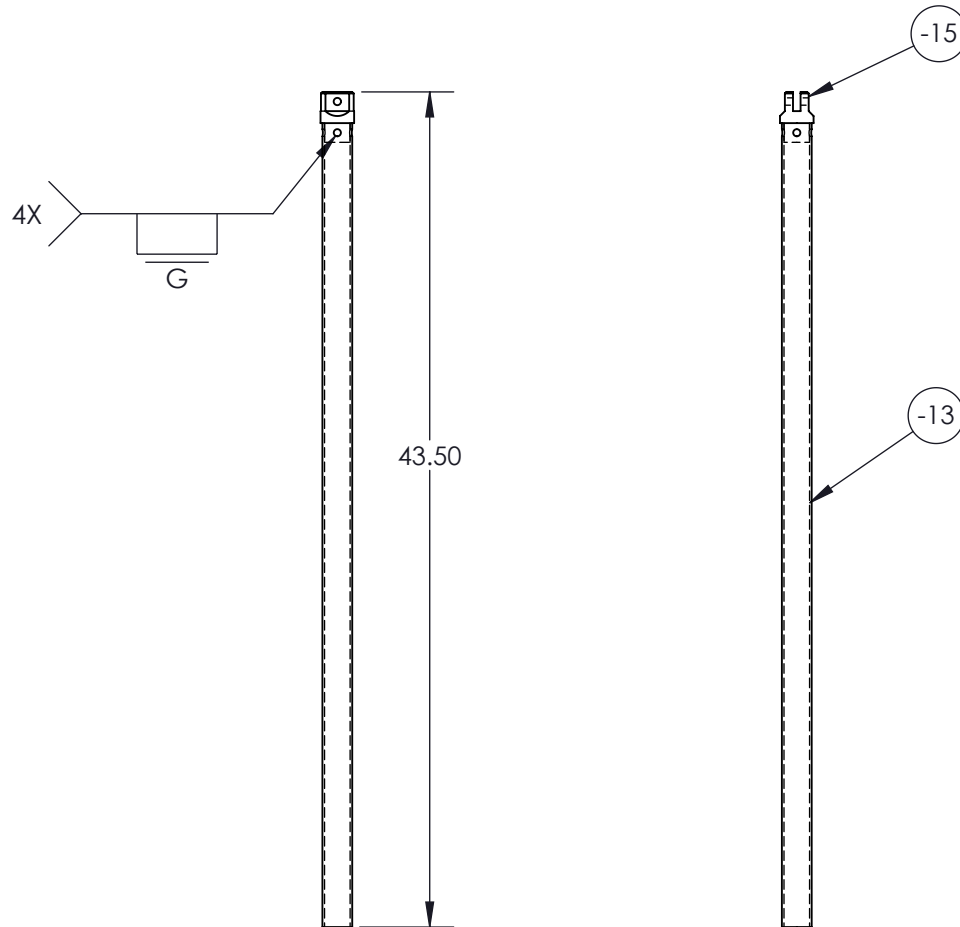
(-9)

CLAMP PLATE, THREADED

DART AEROSPACE	
TITLE TAIL BOOM SUPPORT	
DWG NO. RBE117-30001W2-9	REV 1
MAT'L 6061	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125°
DRAWN BY: RJC 07/10/2017	1. BREAK ALL SHARP EDGES
CHECKED: DD 07/10/2017	.015 x 45° OR .015R
OPPS APPR: AA 07/14/2017	2. DIMENSIONAL LIMITS APPLY
QA APPR: JL 07/19/2017	AFTER PLATING
APPROVED: JAG 07/26/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:1	USED ON MODEL
DATE 7/10/2017	EC145, EC645
	SHEET 6 OF 13

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REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



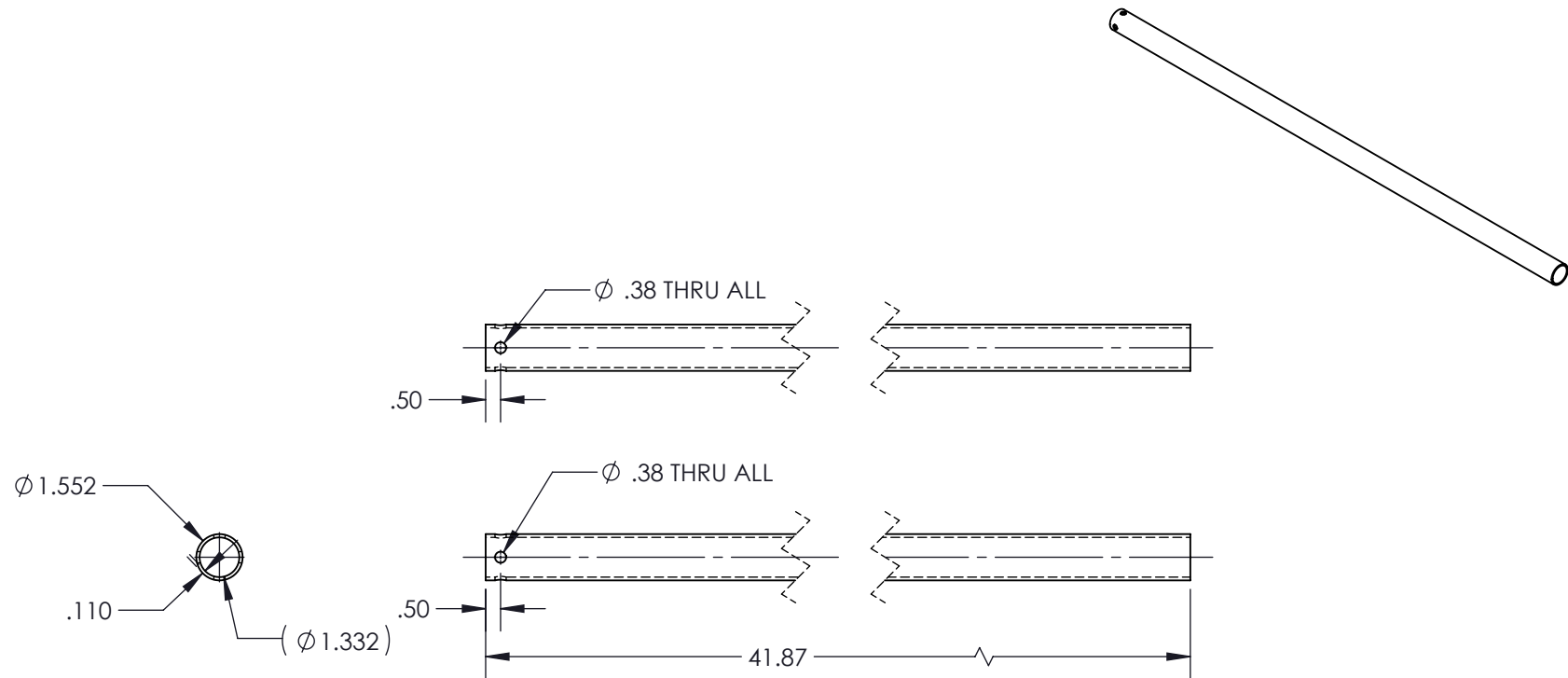
(-11)

INSIDE TUBE WELDMENT

DART AEROSPACE	
TITLE TAIL BOOM SUPPORT	
DWG NO. RBE117-30001W2-11	REV 1
MAT'L HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°
DRAWN BY: RJC 07/10/2017	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 07/10/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 07/14/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 07/19/2017	USED ON MODEL
APPROVED: JAG 07/26/2017	EC145, EC645
SCALE 1:10	DATE 7/10/2017
SHEET 7 OF 13	

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				APPROVED

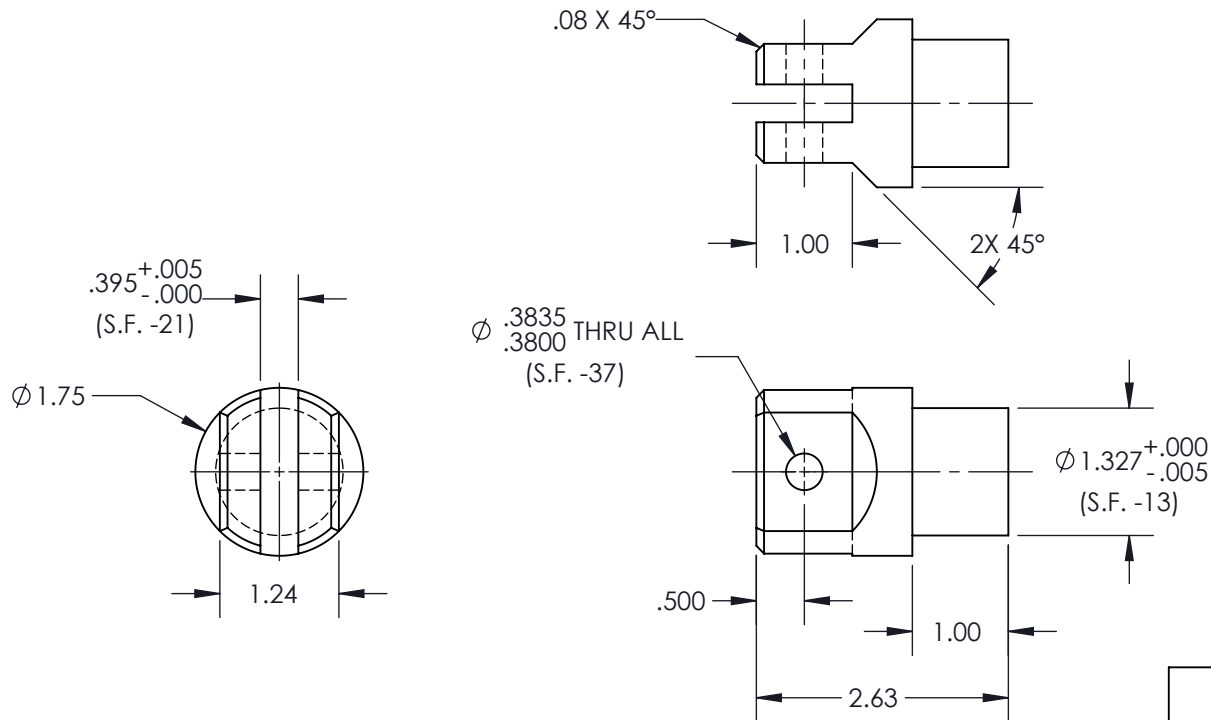
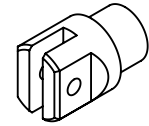


(-13)
INSIDE TUBE

DART AEROSPACE	
TITLE TAIL BOOM SUPPORT	
DWG NO. RBE117-30001W2-13	REV 1
MAT'L 6061 TELESCOPIC TUBE	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE-11	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125/
DRAWN BY: RJC 07/10/2017	1. BREAK ALL SHARP EDGES
CHECKED: DD 07/10/2017	.015 x 45° OR .015R
OPPS APPR: AA 07/14/2017	2. DIMENSIONAL LIMITS APPLY
QA APPR: JL 07/19/2017	AFTER PLATING
APPROVED: JAG 07/26/2017	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:6	USED ON MODEL
DATE 7/10/2017	EC145, EC645
	SHEET 8 OF 13

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				APPROVED



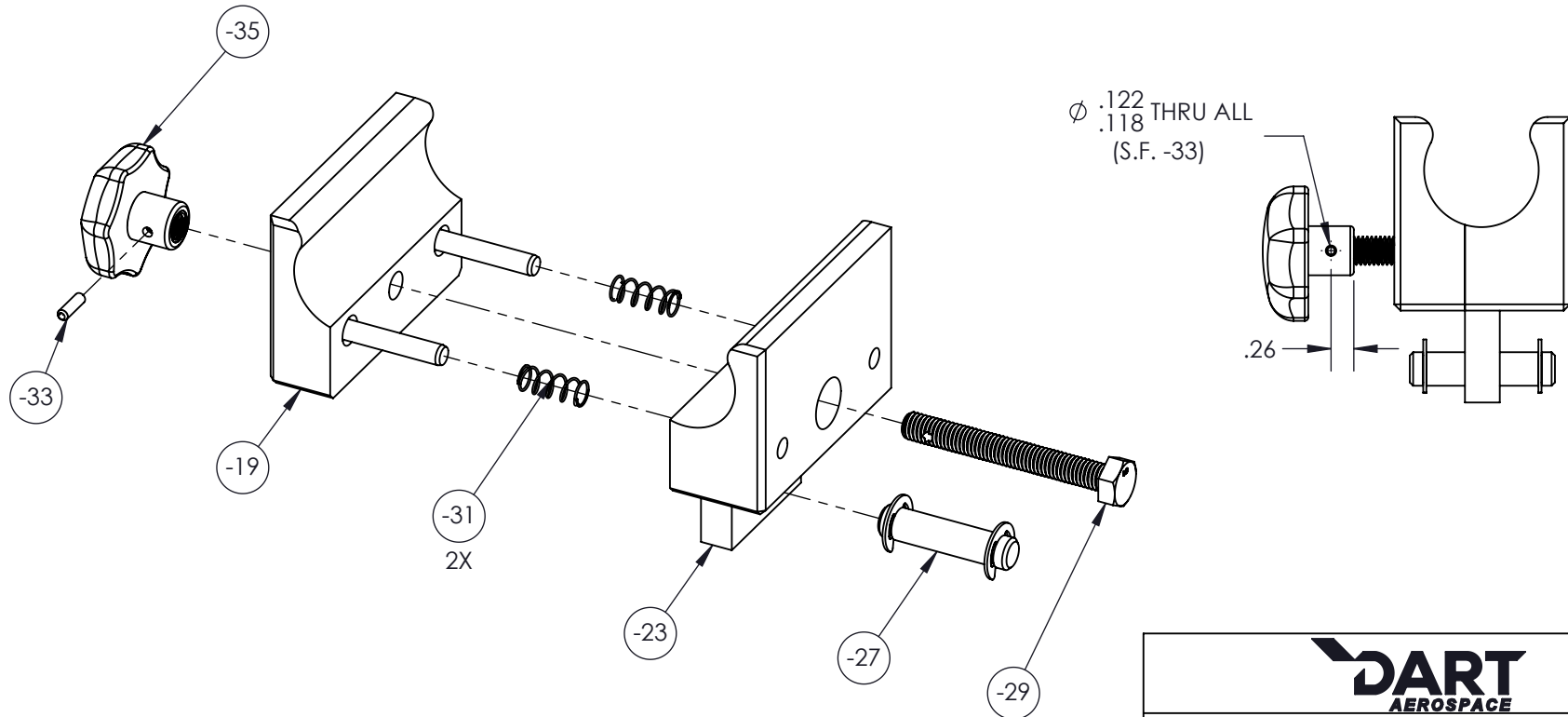
(15)

POST

DART AEROSPACE	
TITLE TAIL BOOM SUPPORT	
DWG NO. RBE117-30001W2-15	REV 1
MAT'L 6061	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -11	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125/
DRAWN BY: RJC 07/10/2017	1. BREAK ALL SHARP EDGES
CHECKED: DD 07/10/2017	.015 x 45° OR .015R
OPPS APPR: AA 07/14/2017	2. DIMENSIONAL LIMITS APPLY
QA APPR: JL 07/19/2017	AFTER PLATING
APPROVED: JAG 07/26/2017	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:2	USED ON MODEL
DATE 7/10/2017	EC145, EC645
	SHEET 9 OF 13

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REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

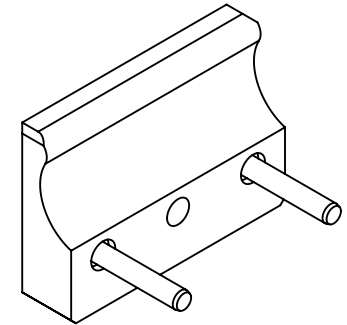
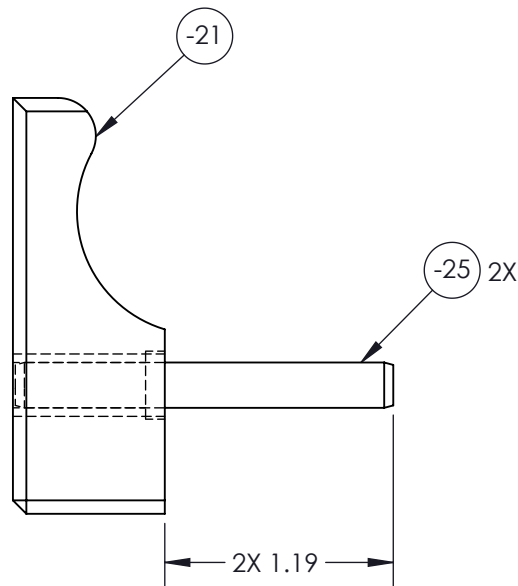


(17)
CRADLE ASSEMBLY

DART AEROSPACE	
TITLE TAIL BOOM SUPPORT	
DWG NO. RBE117-30001-W2-17	REV 1
MAT'L HEAT TREAT FINISH	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125°
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: DD 7/1072017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: AA 07/14/2017	
QA APPR: JL 07/19/2017	USED ON MODEL
APPROVED: JAG 07/26/2017	EC145, EC645
SCALE 1:2	DATE 7/10/2017
SHEET 10 OF 13	

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REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

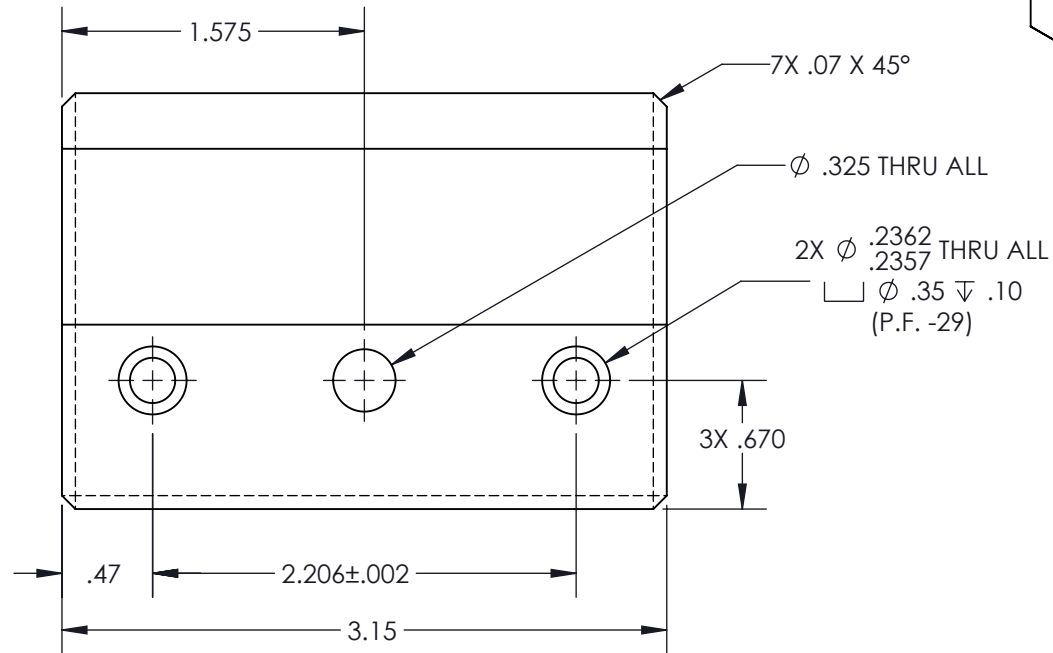
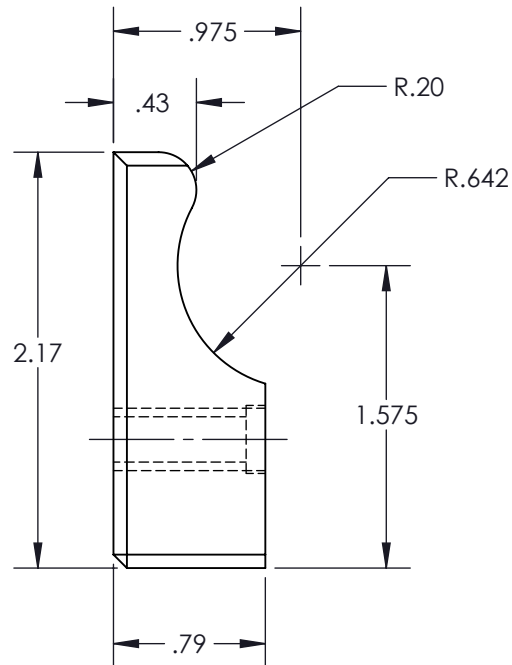
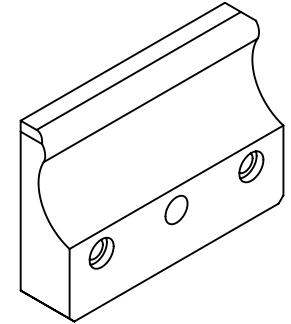


(-19)
UPPER CRADLE ASSEMBLY

DART AEROSPACE	
TITLE TAIL BOOM SUPPORT	
DWG NO. RBE117-30001W2-19	REV 1
MAT'L HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125°
DRAWN BY: RJC 07/10/2017	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 07/10/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 07/14/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 07/19/2017	USED ON MODEL
APPROVED: JAG 07/26/2017	EC145, EC645
SCALE 1:1	DATE 7/10/2017
SHEET 11 OF 13	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED



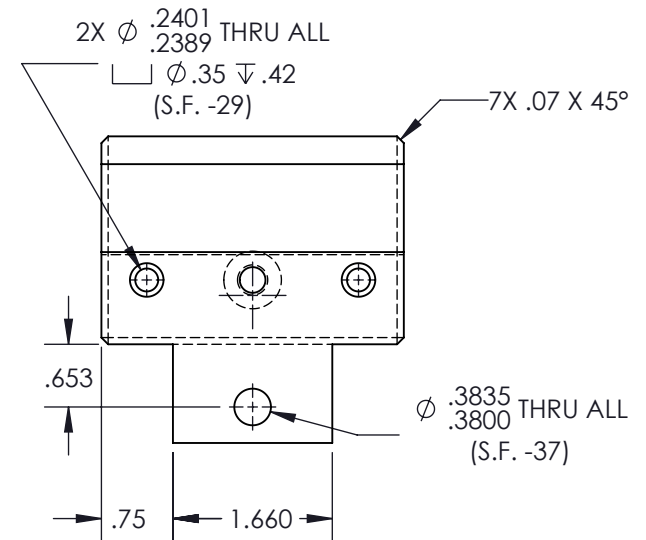
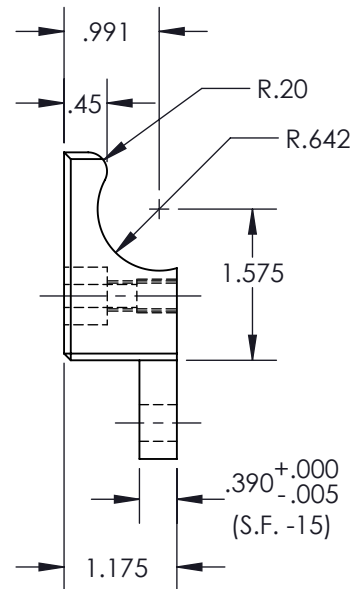
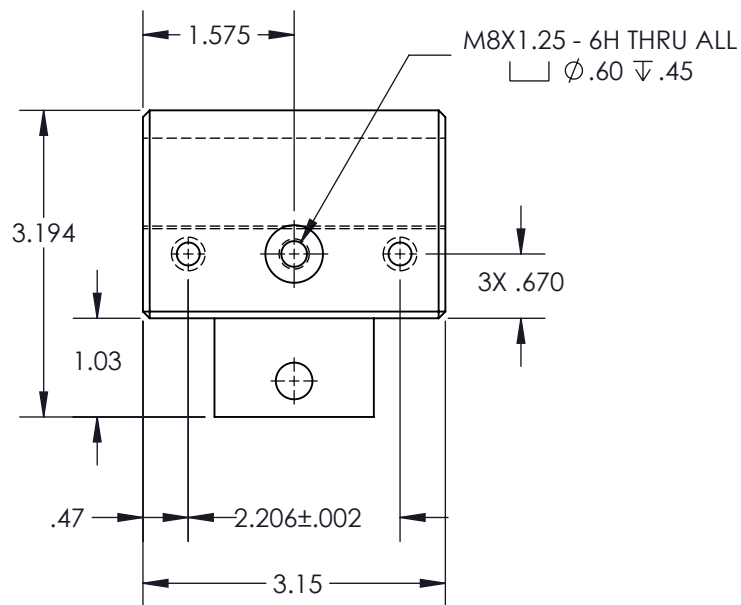
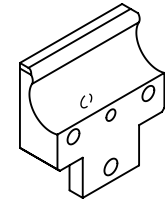
(-21)

UPPER CRADLE CLAMP

DART AEROSPACE	
TITLE EXTRACTOR	
DWG NO. RBE117-30002W1-21	REV 1
MAT'L 6061	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH CLEAR ANODIZE	.XX ± .01 ANGLES ± .5°
SPEC MIL-A-8625F, TYPE II, CLASS I	.X ± .1 SURFACES = 125
DRAWN BY: RJC 07/10/2017	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 07/10/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 07/14/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 07/19/2017	USED ON MODEL
APPROVED: JAG 07/26/2017	EC145, EC645
SCALE 1:1	DATE 7/10/2017
SHEET 12 OF 13	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



(-23)

UPPER CRADLE CLAMP

DART AEROSPACE	
TITLE TAIL BOOM SUPPORT	
DWG NO. RBE117-30001W2-23	REV 1
MAT'L 6061	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT	.XXX \pm .005 FRACTIONS \pm 1/8
FINISH CLEAR ANODIZE	.XX \pm .01 ANGLES \pm 5°
SPEC MIL-A-8625F, TYPE II, CLASS I	.X \pm .1 SURFACES = 125
DRAWN BY: RJC 07/10/2017	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: DD 07/10/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 07/14/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 07/19/2017	USED ON MODEL
APPROVED: JAG 07/26/2017	EC145, EC645
SCALE 1:2	DATE 7/10/2017
SHEET 13 OF 13	